

Gray

Dart Aerospace Ltd.

Date: Wednesday, 15/04/2009 11:12:42 AM
User: Melanie Fauteux

Process Sheet











Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAT BELT GUIDE ASSEMBLY	
Job Number :	47224	Part Number :	D39205	
Estimate Number :	13860	Drawing Number :	D3920 PREL	
P.O. Number :		Project Number :	N/A	
This Issue :	15/04/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	PREL	
First Issue :	11	Type :	MACHINED PARTS	
Previous Run :		Material :		
Written By :		Due Date :	17/04/2009	Qty: 2
Checked & Approved By :	MF 09-04-15		Um: 1	Each
Comment :	Est Rev:A New Issue 09-04-15 JLM Verified By:EC			

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01000	6061-T6 Bar .750 x 1.00
 		
<p>Comment: Qty.: 0.7875 f(s)/Unit Total: 0.7875 f(s) 6061-T6 Bar .750 x 1.00 3.9666 f(s) BATCH: 41527</p>		
2.0	BAND SAW	BAND SAW
 		
<p>Comment: BAND SAW Cut blank 23.800" long</p>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 		
<p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>1- Mill as per Folio FA810 Rev: A & Dwg D3920 Rev: A</p> <p>2-Deburr per dwg D3920</p>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		
5.0	QC8	SECOND CHECK
 		
<p>Comment: SECOND CHECK</p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 11:12:42 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BELT GUIDE ASSEMBLY

Job Number: 47224

Part Number: D39205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

91

09-04-17

(X2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M1109648

START TIME:

10:00am

OVEN TEMPERATURE:

320°F

FINISH TIME:

10:30am

91

09-04-17

(X2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-17 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P.O. #8437

88

09/04/17

(X2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/17 (X2)

Job Completion



09/04/17

POSITIVE RECALL

EFFECTIVE

09/04/17

AUTH U

RELEASED

RJS

DATE

09/04/17

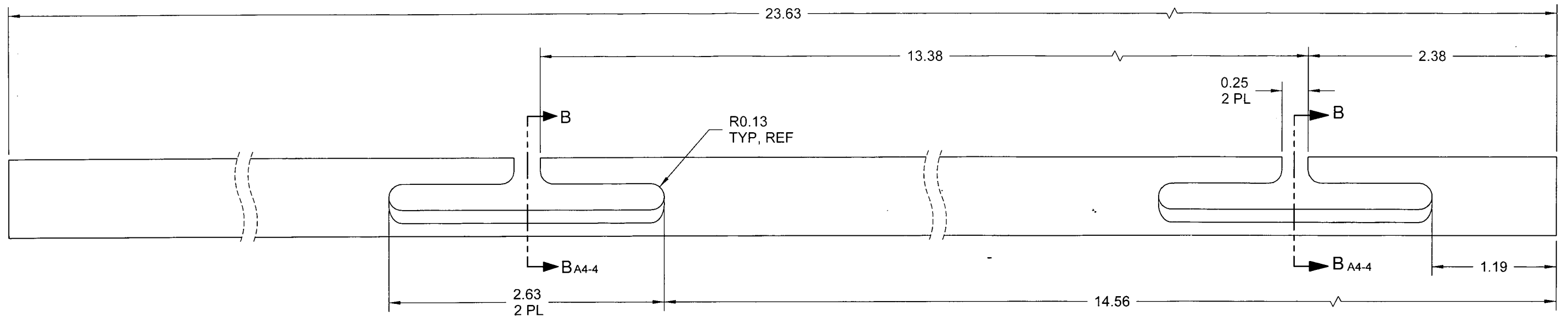
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

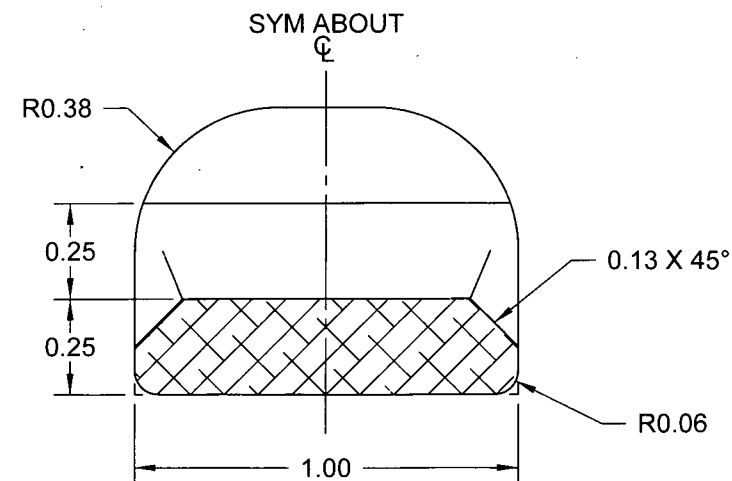
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3920-5 SEATBELT GUIDE



SECTION B-B C2-4 C6-4

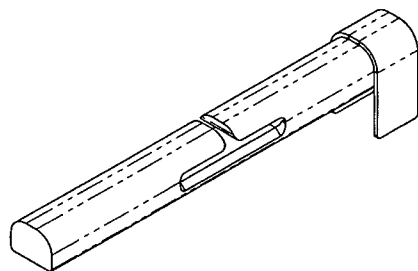
PRELIMINARY
ISSUE
AJS 08.01.14

47224

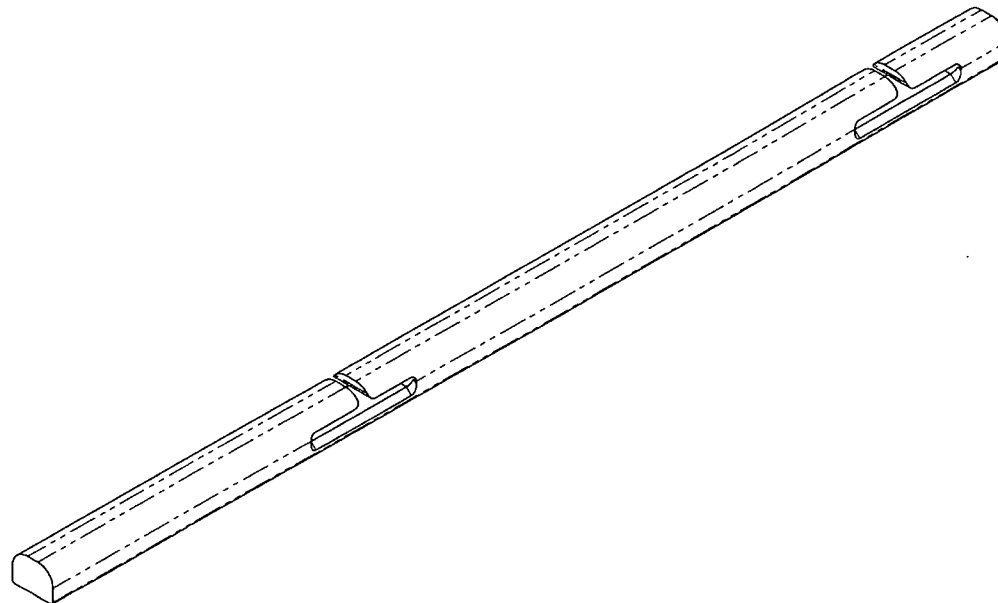
NOTES: D3920-5

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.44 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3920-041 SEATBELT GUIDE ASSEMBLY



D3920-5 SEATBELT GUIDE

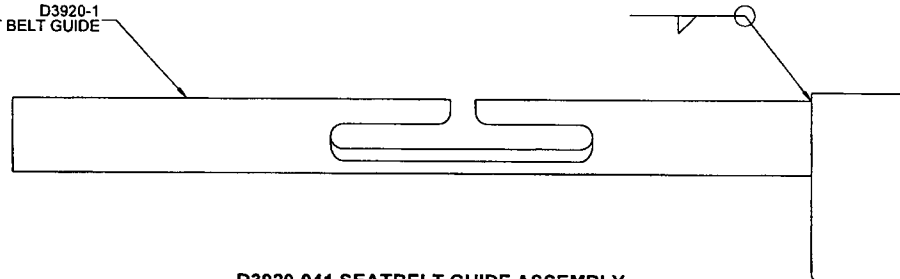
47224

RELEASED
9/6/23/142

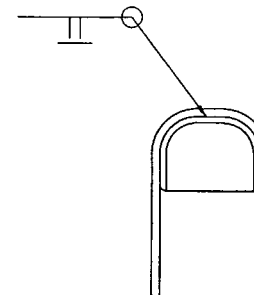
A	NEW ISSUE	AJS	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	21	D3920	SHEET 1 OF 4
APPROVED	142	TITLE	SCALE
DE APPR.	14	SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM No.	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3920-041	SEATBELT GUIDE ASSEMBLY
9	1	D3920-1	SEAT BELT GUIDE
10	1	D3920-3	BRACKET

D3920-1
SEAT BELT GUIDE



D3920-041 SEATBELT GUIDE ASSEMBLY



**D3920-3
SEATBELT GUIDE BRACKET
(ASSEMBLE AT
CHAMFERED END)**

47224

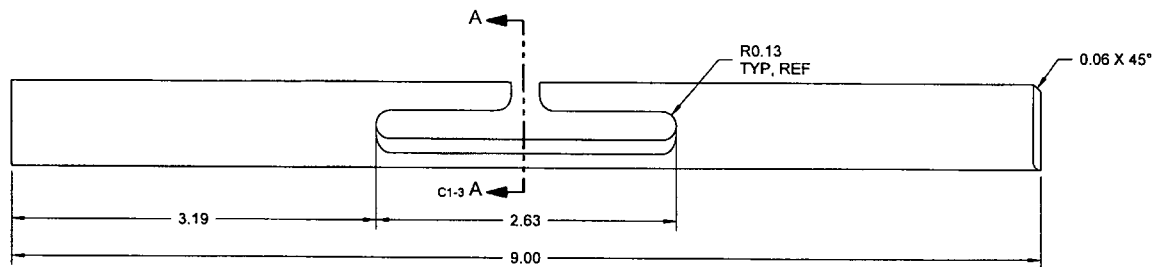
RELEASED
09/14/13 N/A

NOTES: D3920-041

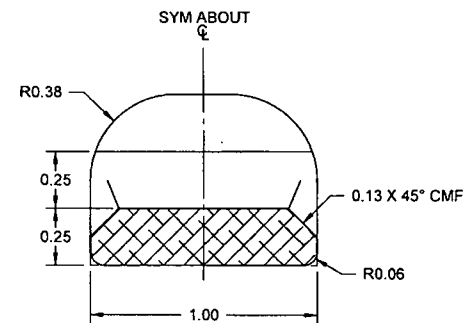
- 1) MATERIAL:
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.57 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

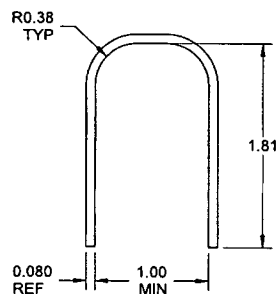


D3920-1 SEATBELT GUIDE

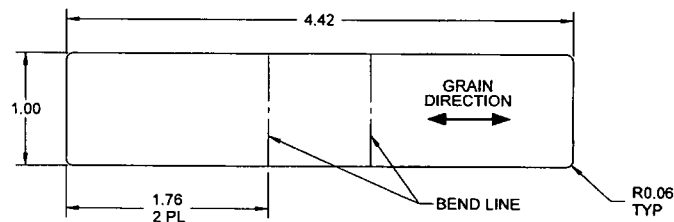


SECTION A-A
SCALE 2X C6-3

47224



D3920-3 SEATBELT GUIDE BRACKET
(MAKE FROM D3920-3F)



D3920-3F FLAT PATTERN

NOTES: D3920-1&3

1) MATERIAL -1: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B

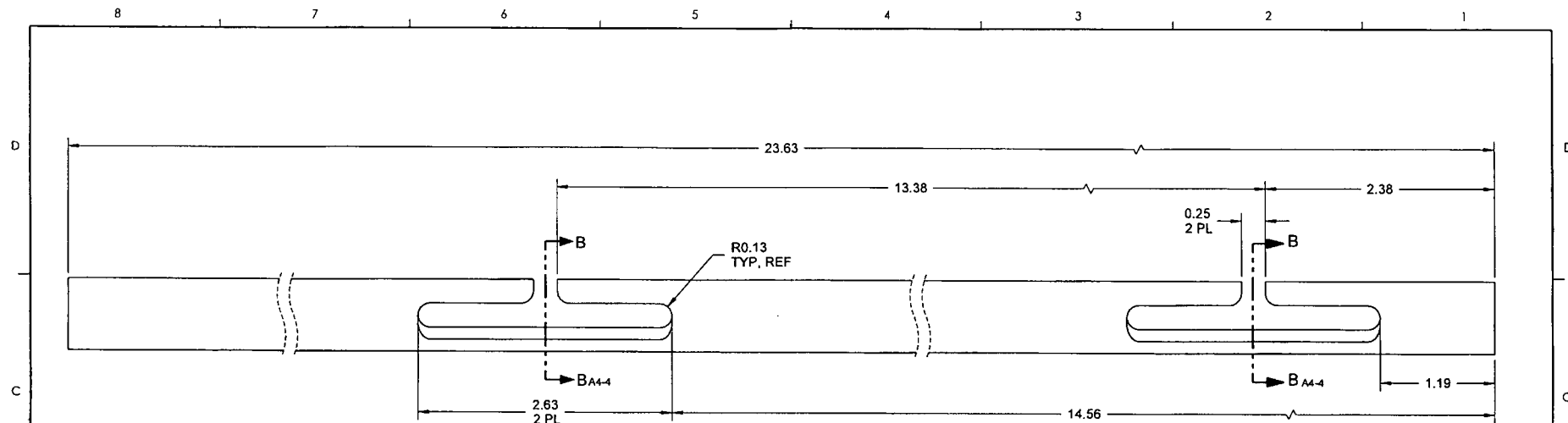
-3: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11
REF DART SPEC M6061T6S.080

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT -1: 0.53 lbs
-3: 0.03 lbs

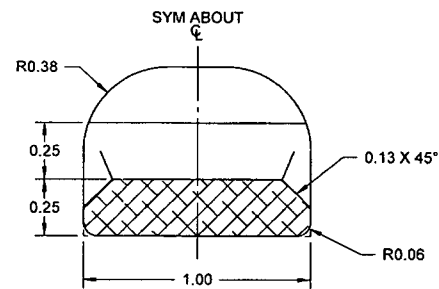
RELEASED
9/6/83 NP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3920	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEATBELT GUIDE ASSY (214B/B1) NTS	
DATE	09.03.30	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1



D3920-5 SEATBELT GUIDE



SECTION B-B

C2-4
C6-4

NOTES: D3920-5

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3920-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.44 lbs

RELEASED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3920	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SEATBELT GUIDE ASSY (214B/B1)	NTS
DATE	09.03.30	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	